

**Bench, shell and casting procedure, in particular for  
engine cylinder heads**

**ABSTRACT**

This invention regards a bench, a shell and a casting  
5 procedure, particularly for engine cylinder heads,  
characterised by low-pressure casting, or the  
introduction of molten metal from a furnace into a shell  
positioned above it, exercising pressure on the surface  
of the molten metal inside the same furnace, combined  
10 with the free-fall feeding of the same shell.

Free-fall casting takes place with open risers created in  
the shell, the latter being sealed at the top, at least  
in line with these risers, by lids moved by a tilting arm  
joined to the casting bench.